

DART

Dart Aerospace Ltd.

1270 ABERDEEN ST
HAWKESBURY ON CANADA K6A 1K7

TC APPROVAL # 09-89

TEL: 1-813-632-5200

P.N.

D350-589-042

CHG

CHG004

DESC.

Side Door Assembly, RH

STC

SH92-41

LOT

B45406

STC

SH1012NE

MODEL

AS350

STC

MADE IN CANADA

D2729-1

Date: Wednesday, 18/02/2009 2:56:16 PM
User: Linda Lacelle

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 45406

Estimate Number : 12296

P.O. Number :

This Issue : 18/02/2009 S.O. No. :

Prsht Rev. : NC

First Issue : 02/02/2009 Type : PURCHASED PARTS

Previous Run : 42910

Part Number : D350589042

Drawing Number : D2991 REV.C

Project Number : N/A

Drawing Revision : C

Material :

Due Date : 20/02/2009

Qty: 1 Um: Each

Written By :

Checked & Approved By :

Comment : est rev. A 06.02.16 new issue (was done on D350-589-041)

EC

Est Rev:B. 08-02-20 ECN1096 DD verified by: EC

est rev C 08.06.26 revised pick list per QC comments

(w/o25886) EC verified : DD



Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D350-589-042

CHG003

CHG 004 pro

2.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 8112

Description: D2991-2 side door

Supplier: Delastek

Ship to delastek: Qty 2 D2992-1 Doubler

batch:

B38743

B46674

Ensure batch # on Label D3721-2 match W/O # for D350-589-042

Certificate of Conformity and process sheet from Delastek is required

3.0

D29921

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Doubler

4.0

D29912

Side Door



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Side Door

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.04.27	1	DZ992-1 NEW WIDER KIT @ CHG 004				GP 09.05.20 DSI 042	S 09/05/20

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Date: Wednesday, 18/02/2009 2:56:16 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 45406

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

**ENGINEERING
APPROVAL**

9/5/14 P 09.05.19
09.05.19
(under review)

6.0

QC6

DIMENSIONAL CHECK



Comment: Ensure Material certification comply to Dwg D2991

7.0

D24641700

Neoprene Seal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part number	Description
1	D2464-1700	Foam seal

Batch

339669

9/5/19

(Signature)

8.0

D2585

Mounting Channel



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty	Part number	Description
3	D2585	Latch clamp

Batch

45816

9/5/19

(Signature)

9.0

D2586

Door Latch



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty	Part number	Description
3	D2586	Door latch

Batch

45554

9/5/19

SP

10.0

D2621

Latch Plate, 350 Spacepod



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty	Part number	Description
3	D2621	latch plate

Batch

41175

9/5/19

(Signature)
SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/02/2009 2:56:17 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 45406

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D3085041

prop ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description
1 D3085-041 prop ass'y

Batch

45057

9/5/19

Sy

12.0

AN960JD10

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part number Description
3 AN960JD10 Washer

Batch

M11127A

9/5/19

sd

13.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part number Description
6 MS21042L3 Nut

Batch

M110844

9/5/19

sd

14.0

MS27039115

Screw



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part number Description
3 MS27039-1-15 Screw

Batch

M110915

9/5/19

sd

15.0

D37212

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Decal

batch: B45493

9/5/19

sd

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg

16.1 Trim to AK as per dwg on edges; batch locations.

16.2

090519

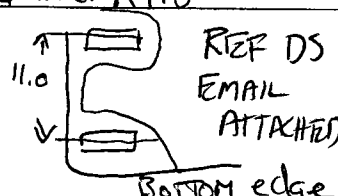
PTO

090520

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
090526	16.	Add one latch and appropriate Hardware Latch clamp D2585 B45815, Door Latch D2586 B45554, Latch plate D2621 B41175, washer AN960JD10 M11279, Nut MS21042 L3 M110844	A	090526	1ea	CP 09.05.27	0905-27
		Screw MS27039-115 M110915, foam seal D2464 -1700 B39669				CP 09.05.27	0905-27

Part No: D350-589-042 PAR #: N/A Fault Category: Eng Design NCR: Yes No DQA: D Date: 09/05/28
 Resolution: Documentation Change Disposition: Re-work QA: N/C Closed Date: 09/05/28

NCR: <u>45406</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
090526	16.	Door does not fit Properly to 350 A/E	CP 09.05.27	Remove core, apply 2 layers of 9e and 9330, fill voids with 9330 and mill fibre, primer filler add one latch	A 090526	090527	CP 09.05.27	090527
			CP 09.05.27	Fibreglass 9e FG 778150550 BM108932 9330 Hysol M110970 milled fibre M100859 primer filler M110582		090527	CP 09.05.27	090527
			CP 09.05.27	 RIER DS EMAIL ATTACHED BOTTOM edge		090527	CP 09.05.27	090527

NOTE: Date & initial all entries

NCR-09-083

Date: Wednesday, 18/02/2009 2:56:17 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 45406

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

D3505-20

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick kit:

19.0

D38941

Switch Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Switch Plate

Batch:

B45526

SS 09/05/20 (X)

20.0

D38951

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch:

B45585

SS 09/05/20 (X)

21.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

3

D2237

Striker Plate

43938

SS (PTO) 09/05/20 (X)

22.0

D2589

Keys, Key Chain, 350 Hinge



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

1

D2589

keys, key chain

B38814

SS 09/05/20 (X)

23.0

AN34A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part number

Description

Batch

6

AN3-4A

Bolt

M103641

SS 09/05/20 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-589-042 PAR #: V/A Fault Category: Eng/Design NCR: (Yes) No DQA: (D) Date: 09/05/08
 Resolution: Documentation Review Disposition: re-work QA: N/C Closed Date: 09/05/08

NCR <u>45406</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
090526	21.	STRiker plate	<u>CP</u> 09.05.27 per QSI/042	include one more striker plate D2237 with Pick Kit BIN 46162	<u>CP</u> 09.05.27 per	<u>(Signature)</u> 090527	<u>CP</u> 09.05.27 per QSI/042	<u>(Signature)</u> 090527

NOTE: Date & initial all entries

NCR 08-023

Date: Wednesday, 18/02/2009 2:56:17 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SIDE DOOR

Job Number: 45406

Part Number: D350589042

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part number Description Batch
6 MS20470AD4-5 Rivet

M109031

PTO →
09/05/20 (K)

25.0

MS21042L3

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Nut

M110844

09/05/20 (K)

26.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

09/05/20 (K)

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Rev D

09/05/20 (K)

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/20

09/05/20

Job Completion



POSITIVE RECALL

EFFECTIVE 09/05/20 AUTH

RELEASED DATE 09/05/20

MF 09-05-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-589-042 PAR #: N/A Fault Category: Eng/Design NCR: Yes No DQA: 10 Date: 09/05/08
 Resolution: Documentation Review Disposition: re-work QA: N/C Closed: 10 Date: 09/05/08

NCR: <u>45406</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
090526	24.	Rivets MS20470AD 4-5	<u>CP</u> 09.05.27 per 051042	include 2 more rivets MS20470 AD4-5 include in pick kit BN M109031	<u>CP</u> 09.05.27	<u>1090527</u>	<u>CP</u> 09.05.27 per 051042	<u>109-0527</u>

NOTE: Date & initial all entries

NCR 08-023

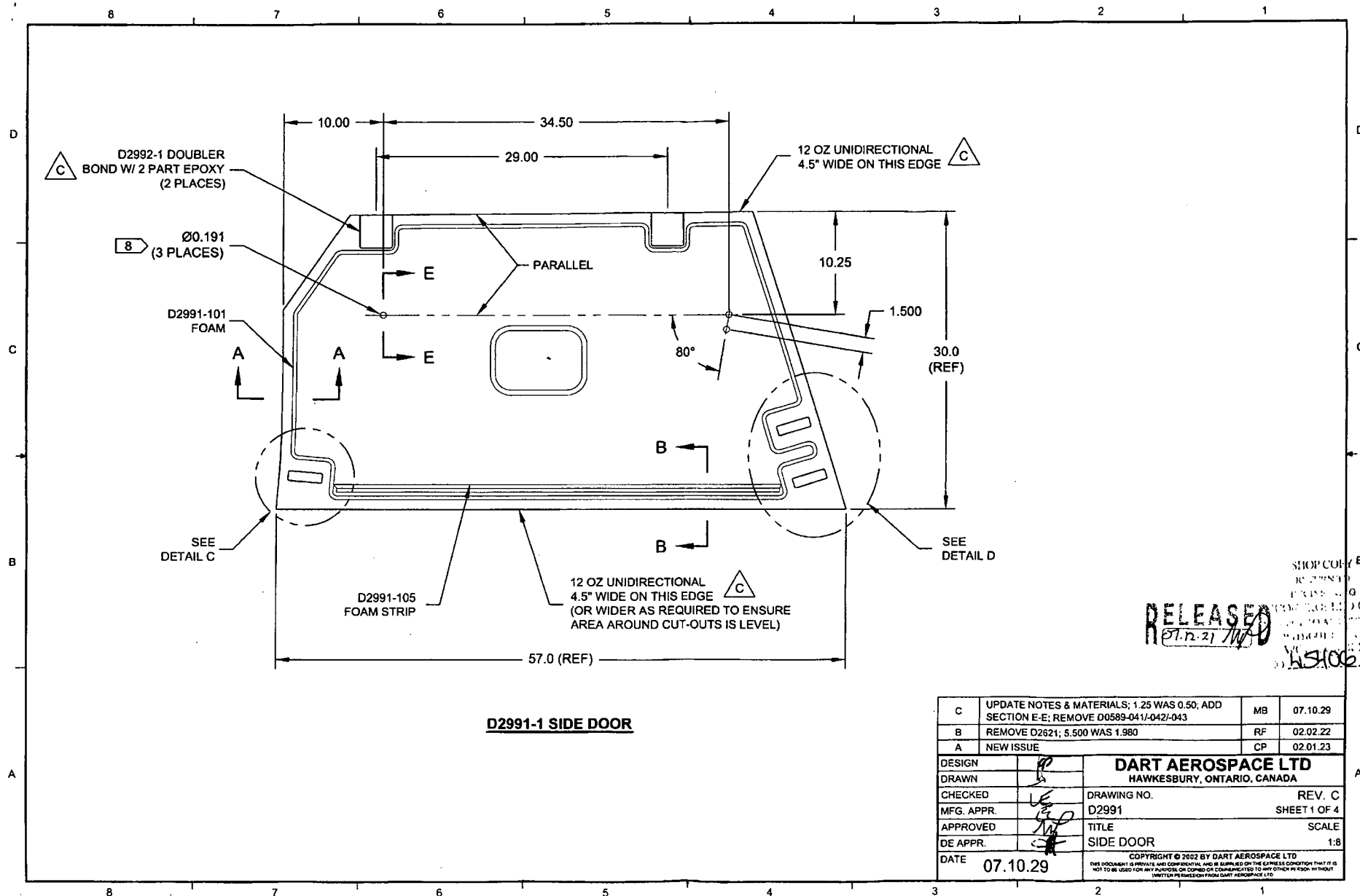
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
07.10.29
151006

C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. C D2991 SHEET 1 OF 4 TITLE SCALE SIDE DOOR 1:8 <small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	JP		
CHECKED	LE		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP		
DATE	07.10.29		

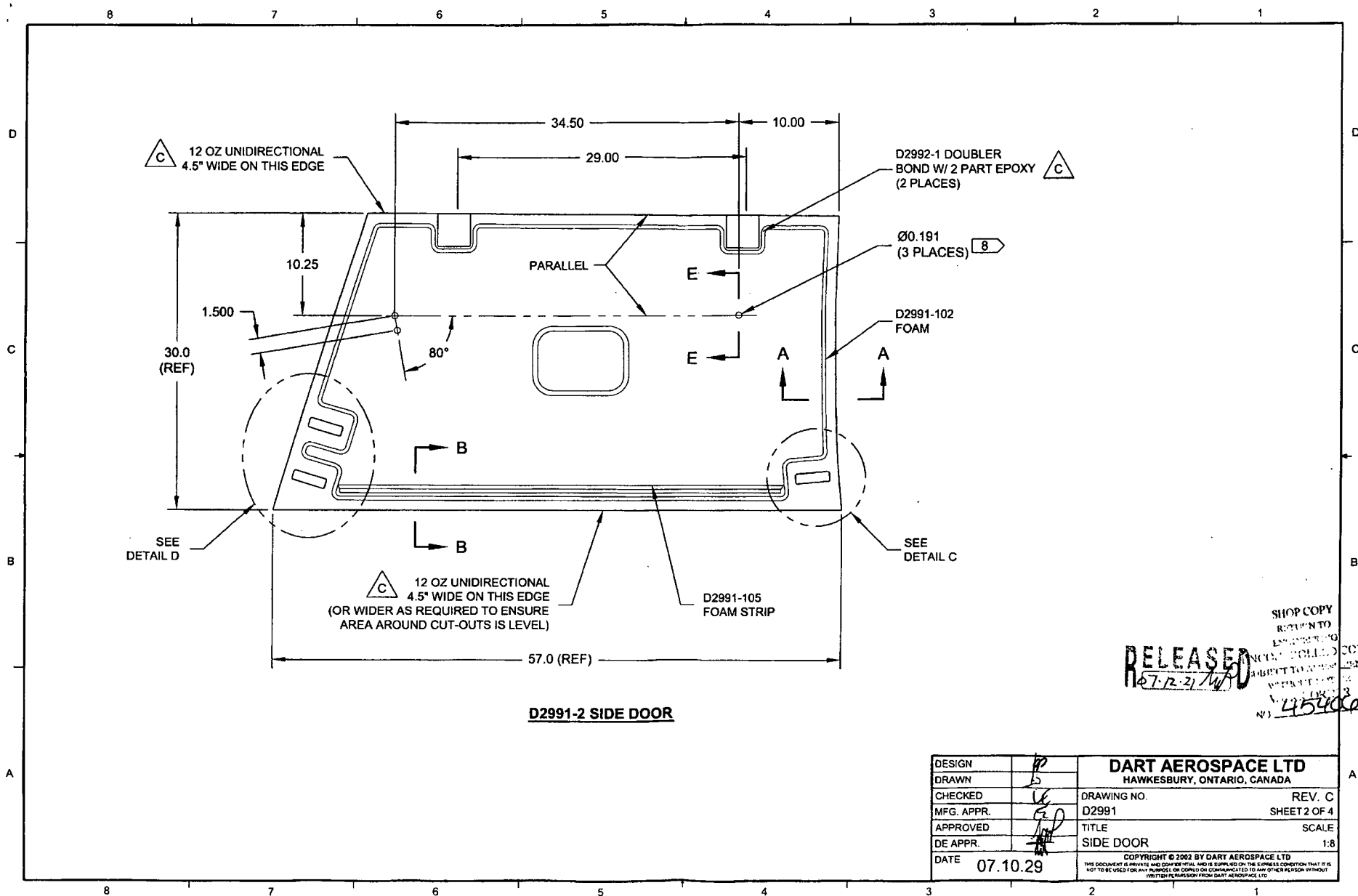
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



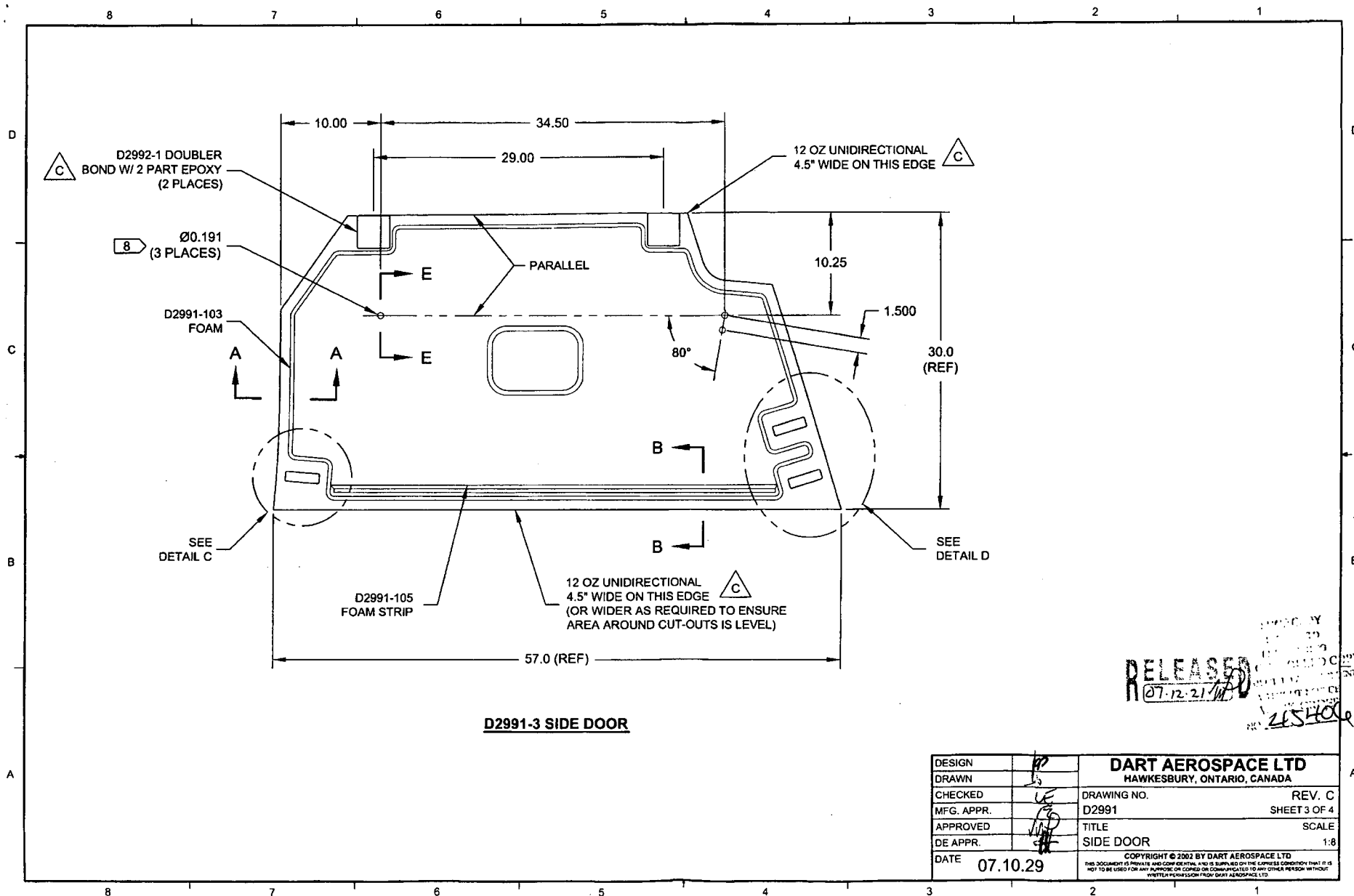
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
07-12-21/17
445406

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2991	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	1:8
DATE	07.10.29	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

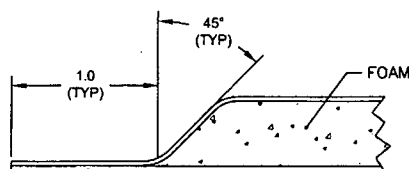
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

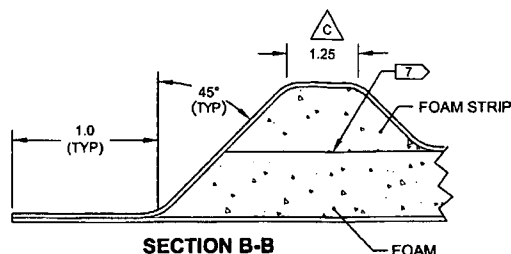
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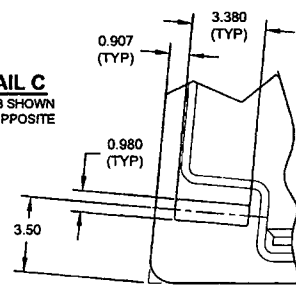
NOTE: Date & initial all entries



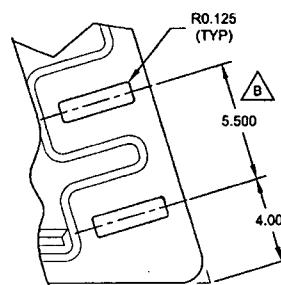
SECTION A-A
NOT TO SCALE
D2991-1/3 SHOWN
D2991-2 OPPOSITE



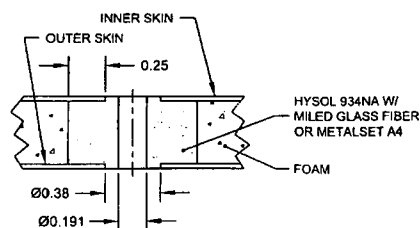
SECTION B-B
ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/3 SHOWN
D2991-2 OPPOSITE



DETAIL C
D2991-1/3 SHOWN
D2991-2 OPPOSITE



DETAIL D
D2991-1/3 SHOWN
D2991-2 OPPOSITE



SECTION E-E
TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE

NOTES FOR D2991-1/2/3

- 1) LAYUP PER QSI 006 AND AS FOLLOWS
- 2) MATERIALS:
RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM: 3/8" A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 3) FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 5) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- 6) MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- 7) BOND FOAM CORE USING POLYBOND B46F
- 8) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1 OR METALSET A4. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- 9) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 10) UNITS: INCHES UNLESS OTHERWISE NOTED
- 11) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 12) IDENTIFICATION: PER D2991-1/2/3 PPPs.
- 13) WEIGHT: 9 lbs (TYP)

RELEASED
07-12-21

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
DATE
NO. 4340

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. C
MFG. APPR.		D2991 SHEET 4 OF 4
APPROVED		TITLE SCALE
DE APPR.		SIDE DOOR 1:5
DATE	07.10.29	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	13158
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
13/05/2009	03/02/2009	5973	Chantal Lavoie		PO00008112		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0050	Side Door N° D2991-1 B45403 Dwg.: D2991 Rév.: C annoté Job: 43778 U de M : Each			
1	0	1	DKC134-0051	Side Door N° D2991-2 B45406 Dwg.: D2991 Rév.: C annoté Job: 43780 U de M : Each			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department

AQ-357



☒ Cust.

☐ Adm.

☐ Quality

☐ Ship.

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Jeudi, 2009-04-23 08:40:47
 Utilisateur: Marc Dubé

Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : SIDE DOOR N° D2991-2	
Numéro Job : 43780		Numéro Article : DKC134-0067 - 005 P	
Numéro Soumission : 2644		Numéro Dessin : D2991	
Numéro B.A. :		Projet Numéro : DKC134	
Cette fois : 2009-04-23	No. B.V. :	Révision dessin : C ANNOTÉE	
Prsht Rev. : NC		Matériel : Composites	
Prem. fois : - -	Type :	Date Dûe : 2009-04-30	Qté: 1 Udm: UNITE
Job précédente : 43699			

Écrit par : _____

Vérifié & Approuvé par : _____

Commentaires : N° de pièce Client: D2991-2

Process Sheet Rev.: 00 Création du premier.

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 AAC0582 Frekote 700NC N° 38425

Commentair Qty.: 0.025 GALLON(s)/Unit Total : 0.025 GALLON(s)

2.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation du moule N° DKO-0095 selon le QSI-006 et selon IG 0009.

Date: 23-4-09 Sceau:



3.0 AAC0273 Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)

4.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0250 PINTE(s)/Unit Total : 0.0250 PINTE(s)

5.0 AAC0198 UN2055 styrene monomere ST

Commentair Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s)

6.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Dans une quantité de 0.2 gallon de Gel Coat N° 944W005 ajouter 2% de Catalyst N° DDM-9 et diluer à l'aide de 10% de UN2055 styrene monomere ST

Date: 23-4-09 Sceau: Temps Début: 9:00 Temps Fin: 9:15



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: JEUDI, 2009-04-23 06:40:47
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43780

Nom Dessin: SIDE DOOR N° D2991-2
Numéro Article: DKC134-0067

Numéro Job:



Séq.:

Machine ou Opération:

Description :

7.0

GEL COAT.

APPLICATION DE GEL COAT



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Faire l'application du Gel coat sur le moule N° DKO-0095 selon IG 0019

Date: 23-4-09 Sceau:



8.0

AC0409

Tissu à délaminer Release ply B

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

9.0

AC0407

Wrightlon 5200 Bleu P3

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

10.0

AC0408

Feutre de drainage N° Airweave N 10

Commentair Qty.: 5.43 VERGE(s)/Unit Total : 5.43 VERGE(s)

11.0

AC0752

Stretchlon 200 poche à vide Vert

Commentair Qty.: 12.00 PIED(s)/Unit Total : 12.00 PIED(s)

12.0

AAC0276

Fiberglass 9oz Type "S" N° FG778138-125Y

Commentair Qty.: 7.30 VERGE(s)/Unit Total : 7.30 VERGE(s)

13.0

AAC0443

Fiberglass 12 oz Unidirectional

Commentair Qty.: 4.00 VERGE(s)/Unit Total : 4.00 VERGE(s)

14.0

AC0098

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 3.0000 RL(s)/Unit Total : 3.0000 RL(s)

15.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 15-4-09 Sceau:



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Jeudi, 2009-04-23 08:40:47
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43780

Nom Dessin: SIDE DOOR N° D2991-2
Numéro Article: DKC134-0067

Numéro Job:



Séq.: Machine ou Opération: Description :

16.0 AAC0274 Derakane 411-350 Promoté N° RV411B3020

Commentair Qty.: 1.700 KILOGRAMME(s)/Unit Total: 1.700 KILOGRAMME(s)

1-24094-1

17.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0060 UNITE(s)/Unit Total: 0.0060 UNITE(s)

1-22176-1

18.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 23-4-09 Heure Début: 1:10 Heure Fin: 1:15 Sceau: 34

19.0 LAMINAGE LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DKO-0095 et ensuite imbiber un pli de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 23-4-09 Heure Début: 1:15 Heure Fin: 1:30 Sceau: 34 7

20.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Date: 23-4-09 Sceau: 34 7

Curing début: 1:15 Curing Fin: 9:20

21.0 AAC0452 Polybond B46F

Commentair Qty.: 0.143 KIT(s)/Unit Total: 0.143 KIT(s)

1-6724-1

22.0 DKC134-0063 Foam Core N° D2991-102(Porte D2991-2)

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

43655

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: JEUDI, 2009-04-23 08:40:47
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 43780

Nom Dessin: SIDE DOOR N° D2991-2
Numéro Article: DKC134-0067

Numéro Job:



Séq.:

Machine ou Opération:

Description :

23.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Assembler le Foam Core DKC134-0063 Selon IG 0033

Date: 24-4-09 Heure Début: 11:20 Heure Fin: 11:35 Sceau:  

24.0



POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012

Date: 24-4-09 Sceau:  

Curing Début: 11:20 Curing Fin: 12:35

25.0

AAC02743

Derakane 411-350 Promote N° RV411B3020

Commentair Qty.: 1.700 KILOGRAMME(s)/Unit Total : 1.700 KILOGRAMME(s)

1-24094-1

26.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0040 UNITE(s)/Unit Total : 0.0040 UNITE(s)

1-22176-1 ✓

27.0


PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 1-5-09 Heure Début: 1:45 Heure Fin: 1:50 Sceau: 

28.0

LAMINAGE

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 1-5-09 Heure Début: 1:50 Heure Fin: 2:45 Sceau:  

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
















Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Jeudi, 2009-04-23 08:40:47
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SIDE DOOR N° D2991-2	
Numéro Job: 43780		Numéro Article: DKC134-0067	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
29.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs			
Faire la poche à vide selon IG 0012			
Laisser sécher pendant 4 heures minimum.			
Date: <u>4-5-09</u> Heure Début: <u>2:45</u> Heure Fin: <u>2:55</u> Sceau:  			
Curing Début: <u>1:50</u> Curing Fin: <u>8:00</u>			
30.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART	
			
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs			
Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ". Selon l'instruction générale de fabrication N° IG 0018			
Date: <u>4-5-09</u> Sceau:  			
31.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs			
À l'aide du gabarit N° <u>DKO-0119</u> trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.			
Perçer les " Latch " et les trous de peinture selon le dessin N° D2991.			
Date: <u>4-5-09</u> Sceau:  			
32.0	AAC0433	Hysol 934NA part A&B (quart kit)	
Commentair Qty.: 0.150 KIT(s)/Unit Total : 0.150 KIT(s) <u>1-22083-1</u>			
33.0	AAC0673	Fibre de verre Miapoxy 66	
Commentair Qty.: 0.0002 GALLON(s)/Unit Total : 0.0002 GALLON(s) <u>1-6872-1</u> ✓			
34.0	TRIMAGE 3	TRIMAGE COMPOSITES DART	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
À l'aide du Gabarit N° <u>DKO-0119</u> Perçer les 3 trous de 1/4" Dia.			
À l'aide d'une clé Allen et en faisant bien attention de ne pas abimer les Skins de la pièce, venir faire un dégagement de 1/2" Dia dans le Foam Core en tre les Skin intérieur et extérieur.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: JEUDI, 2009-04-23 08:40:47
Utilisateur: Marc Dubé

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.
Numéro Job: 43780

Nom Dessin: SIDE DOOR N° D2991-2
Numéro Article: DKC134-0067

Numéro Job:



Séq.:

Machine ou Opération:

Description :

À l'aide de masking Tape, masquer le trous de la skin extérieur.

À l'aide d'un mélange de résine Hysol 934NA / Fibre courte Miapoxy 66 et d'une seryngue, venir remplir les dégagements de 1/2" Dia préalablement fait dans le foam Core.

Laisser sécher.

Date: 5-5-09 Sceau:



35.0

TRIMAGE

TRIMAGE DE FINITION



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N° DKC-0119 Repercer les 3 trous de 1/4" Dia.

Date: 6-5-09 Sceau:



36.0

AAC0433

Hysol 934NA part A&B (quant kit)

ARALDITE 2043

Commentair Qty.: 0.125 KIT(s)/Unit Total : 0.125 KIT(s)

37.0

AAC0697

N° D2992-1, Doubler

1-7063-1

Commentair Qty.: 2 UNITE(s)/Unit Total : 2 UNITE(s)

38.0

ASSEMBLAGE

ASSEMBLAGE GÉNÉRALE DES PIÉCES



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide de l'adhésif N° Hysol 934NA, assembler le doubler N° D2992-1 sur la pièces de composite selon le dessin.

Date: 5 mai 09 Sceau:



39.0

AAC0683

Dupont Primer N° 7704S

Commentair Qty.: 0.1800 UNITE(s)/Unit Total : 0.1800 UNITE(s)

1-22968-1

40.0

AAC0685

Dupont Activator - Reducer Chromabase N° 7775S

Commentair Qty.: 0.0450 UNITE(s)/Unit Total : 0.0450 UNITE(s)

1-23133-2

41.0

PRIMER

APPLICATION DE PRIMER



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Appliquer le primer selon I.G. 0008

08/05/09



Date: 07/05/09 Sceau:



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____








Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

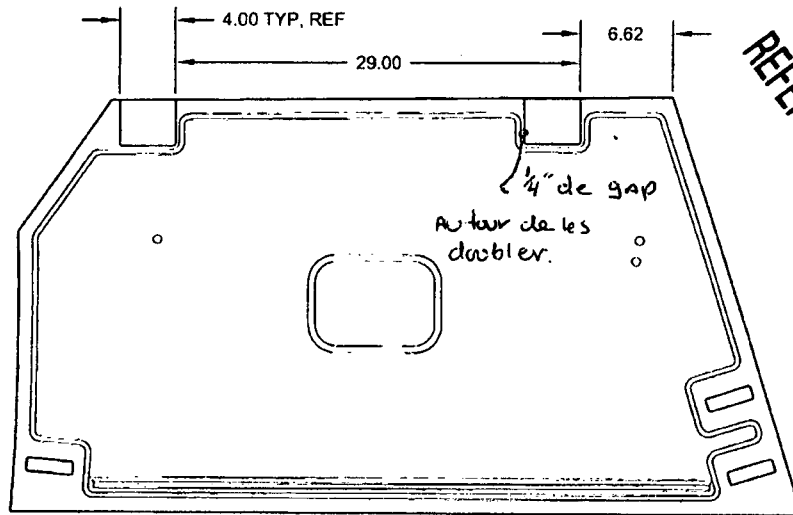
NOTE: Date & initial all entries

Date: Jeudi, 2009-04-23 08:40:47
Utilisateur: Marc Dubé

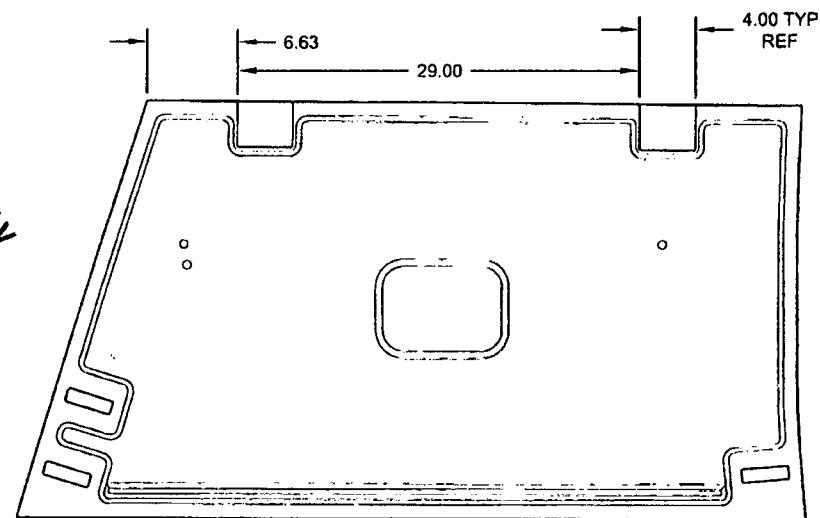
Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: SIDE DOOR N° D2991-2	
Numéro Job: 43780		Numéro Article: DKC134-0067	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
42.0	INSPECTION 3	INSPECTION PIÈCE DART	
			
Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs			
Faire l'inspection selon le dessin N° D2991			
Date: 13-5-09 Heure Début: 11h00 Heure Fin: 11h15 Sceau: 			
43.0	EMBALLAGE	EMBALLAGE ET ENTREPOSAGE	
			
Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs			
Faire l'emballage des pièces.			
Quantité: 1 Date: 13-5-09 Sceau: 			

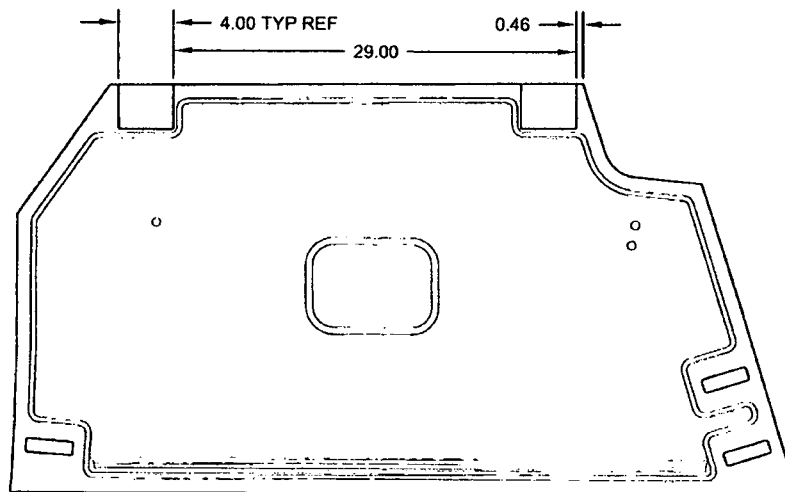
REFERENCE ONLY



D2991-1 SIDE DOOR



D2991-2 SIDE DOOR



D2991-3 SIDE DOOR

S.V.P. suivre les dimensions
ici. La point d'origine est acceptable
dans la coin du lay-up.

Jasen Murdoch
09/04/29

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSK 123	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	NIS
DATE	09.04.28	COPYRIGHT © 2009 BY DART AEROSPACE LTD	

Chris Provencal

From: dshepherd@dartaero.com
Sent: May 27, 2009 2:06 PM
To: Chris Provencal
Cc: Mike Petsche
Subject: Re: Need approval on D350-589 Mod

Chris,

Sounds/looks ok to me. They can send out the door today. I will review the DSI in more detail tomorrow and sign it off.

David

Sent from my BlackBerry device on the Rogers Wireless Network

From: "Chris Provencal"
Date: Wed, 27 May 2009 12:56:10 -0400
To: 'David Shepherd' <dshepherd@dartaero.com>
Subject: Need approval on D350-589 Mod

David,

A D350-589-041 and D350-589-042 door were modified with an extra latch on the trailing edge. Dan sent pictures of the mod. The latch was placed 11" above the lower latch. The foam core was removed from the area and two layers of 9oz cloth were layered up on the inner surface. Latch hardware was installed identical to the other locations. The kit will include an additional striker plate and associated rivets. I've prepared a DSI that I will get to you when you're available.

Is this mod acceptable?

Sincerely,
Christopher Provencal
DART Aerospace Ltd.

cprovencal@dartaero.com
Tel: (613) 632 5200
Fax: (613) 632 9311